



Dart Aerospace Ltd.
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Tel (613) 632-5200

D350-591-213
Job Sheet 178756



Part No: D350-591-213

Job Qty: 4 ea

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Aerazur Float Compatible



JUN 25 2018

Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/7/18

Job Tracking No:

Due Date: 7/4/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLMIPP REV:D 14.12.17 ADD DSI9712-011 DD VERF:JLM IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM IPP Rev:E 10.11.15 update qty on AN4-11A DD ver:EC IPP REV:F 16.03.16 IIN REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	7/4/18	7/4/18	0.00	0.00	Start Up Stores/Pkg-2		JUN 25 2018
270	Packaging	4 pcs	7/4/18	7/4/18	0.00	0.00	Packaging1-3		JUL 05 2018
280	QC	4 pcs	7/4/18	7/4/18	0.00	0.00	QC4		
290	Packaging	4 pcs	7/4/18	7/4/18	0.00	0.00	Packaging3-1		
295	DC	4 pcs	7/4/18	7/4/18	0.00	0.00	DC		
300	QC21-FG	4 Ea	7/4/18	7/4/18	0.00	0.00	QC21		JUL 05 2018

Part Op 290 - Identify and pack for shipping as per PPP D350-591-213

Descriptions: 295 - Photocopy bluefile and type labels as per PPP D350-591-213 CHG005

Fg039 2x sold

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-35A	Bolt	8 Ea (2 ea)	90-Start up Operation	5087891
AN4-15A	Bolt	16 Ea (4 ea)	90-Start up Operation	5057424
AN5-36A	Bolt	8 Ea (2 ea)	90-Start up Operation	5068156
D2230-3	Mounting Lug	8 Ea (2 ea)	90-Start up Operation	5085080
D2618	Bushing	8 Ea (2 ea)	90-Start up Operation	5049859
D2732-033	Rubber Cushion (\$Per Foot)	4 Ea (1 ea)	90-Start up Operation	5073491
D3078-041	Step Assembly, Hi Short LH	4 Ea (1 ea)	90-Start up Operation	5081100
D3235-1	Mounting Lug	8 Ea (2 ea)	90-Start up Operation	5069974
D3338-1	Mounting Lug	4 Ea (1 ea)	90-Start up Operation	5080379
MS21042L3	Nut	8 Ea (2 ea)	90-Start up Operation	5078167
MS21042L4	Nut	24 Ea (6 ea)	90-Start up Operation	5067898
MS21042L5	Nut	8 Ea (2 ea)	90-Start up Operation	5058178
NAS1149D0363J	Washer	16 Ea (4 ea)	90-Start up Operation	5015269
NAS1149D0463J	Washer	48 Ea (12 ea)	90-Start up Operation	5067902
NAS1149D0563J	Washer	16 Ea (4 ea)	90-Start up Operation	5068662

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-35A	8	308	0
	AN4-15A	16	289	0

Work Order: _____

Part No. _____

NCR No. _____

Date: _____

DISPOSITION

Rework ☐

Scrap ☐

Use ☐

Skid-tube ☐

Material ☐

Crack ☐

AGAINST DEPARTMENT/PROCESS

Water Jet ☐

Prod. Eng. Coord. ☐

Store/Packaging ☐

Supplier ☐

Engineering ☐

Quality ☐

Other ☐

Describe

Completed By

Lead hand / Supervisor Approval Verification

QC / QA Coordinator Approval

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www.dartaerospace.com

Date: 06/25/18

DART
AEROSPACE

Container No: S083997

Part: D350-591-213

Job No: 178756

Serial No/Batch: S083997

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: _____

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Cracks	☐	BOM/Route	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Crimp/Kink/Ripple/Wave	☐	Broken/Damage/Defect	☐	Folio/Program	☐	Outside Dimensions	☐
Cuffs	☐	Inspection Incomplete/Unqualified	☐	Grain	☐	Over/Under tolerance	☐
Crushing	☐	Contamination	☐	Weld	☐	Part Incorrect	☐
Heat Treat	☐	Countersink	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Wave/Twist in Tube	☐	Cut Too Short	☐	Out of Sequence	☐	Part Moved	☐
Marks/Chatter	☐	Instructions Incomplete/Unclear	☐	Off-set	☐	Drawing	☐
	☐	Drill Holes	☐	Mislabeled	☐	Finish	☐
	☐		☐	Fit/Function	☐	Mistread	☐
	☐		☐	Misaligned/off center	☐	Turning Sequence	☐

OTHER : _____

H:/FORMS/Quality Assurance/approved QA/NCRWO Rev I

AN5-36A	8	306	0
D2230-3	8	20	0
D2618	8	154	0
D2732	4	363	0
D3078-041	4	10	0
D3235-1	8	246	0
D3338-1	4	29	0
MS21042L3	8	1,923	0
MS21042L4	24	3,141	0
MS21042L5	8	661	0
NAS1149D0363J	16	2,235	0
NAS1149D0463J	48	5,339	0
NAS1149D0563J	16	2,099	0

Part Specifications

Specifications could not be found.

Plex 6/7/18 10:49 AM dart.lajeunesse.marie

Part Number: D350-591-213/-213GB/-214/-214GB

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH/RH

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1
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REF. ONLY

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.